

Amendments To The Claims:

Please amend the claims as shown.

1 – 7 (canceled)

8. (new) A turbine rotor shaft, comprising:

a middle region having a middle region material and a longitudinal axis and having a first end face oriented perpendicular to the longitudinal axis and arranged at an a first end of the middle region and a second end face arranged at a second end of the middle region opposite the first end face;

a first outer region having a first material and arranged coaxially with the longitudinal axis abutting the first end face of the middle region; and

a second outer region having a second material and arranged coaxially with the longitudinal axis and abutting the second end face of the middle region wherein the middle region material has a higher heat resistance than the first and second materials.

9. (new) The turbine shaft as claimed in claim 8, wherein the first and second outer regions are welded to the middle region.

10. (new) The turbine shaft as claimed in claim 9, wherein the middle region material is a forging steel having 9 to 12% by weight of chromium and the first and second materials are steels having 1 to 2% by weight of chromium.

11. (new) The turbine shaft as claimed in claim 10, wherein the first and second outer region materials are different.

12. (new) The turbine shaft as claimed in claim 11, wherein the middle region is exposed to steam at 550°C and 250 bar.

13 (new) The turbine shaft as claimed in claim 8, wherein the middle region material is nickel based.

14. (new) A method for manufacturing a turbine shaft, comprising:  
producing a middle region from a heat-resistant material;  
producing a first outer region from a material that is less heat-resistant than the middle region material;  
producing a second outer region from a material that is less heat-resistant than the middle region material; and  
welding the first and second outer regions opposite ends of the middle region.

15. (new) A steam turbine, comprising:  
a turbine shaft arranged coaxial with a rotational axis of the turbine wherein the shaft has  
a middle region having a middle region material and first and second end faces oriented perpendicular to the longitudinal axis of the shaft arranged at opposite ends of the middle region,  
a first outer region having a first material and arranged coaxially with the longitudinal axis abutting the first end face of the middle region, and  
a second outer region having a second material and arranged coaxially with the longitudinal axis and abutting the second end face of the middle region wherein the middle region material has a higher heat resistance than the first and second materials;  
a plurality of blades attached to the first outer and second outer regions of the turbine shaft;  
an inner casing surrounding the turbine shaft;  
a plurality of vanes attached to an inner surface of the inner casing; and  
an outer casing that surrounds the inner casing.